

Work Order ID 71130

Thursday, June 23, 2011 11:07:09 AM



Page 1

Item ID: D3504-1

Accept



Setup Start



Revision ID:

Item Name: Crossbolt Spacer

Stop



Start Date: 6/23/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/06/23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3504	Rev C								

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA642 & DWG D3504

FOLIO REV: 11/7/16

DWG REV: 11/7/16

2-DEBURR AS REQUIRED

SL 11/7/16

25 0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11/7/16

25 0

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

DR 11.7.6

25 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71130

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Item ID: D3504-1

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Start Date: 6/23/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

25 0 BEN/07/19

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/20 ME 11-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 11:07:06 AM

Page 1

Work Order ID: 71130

Parent Item: D3504-1

Parent Item Name: Crossbolt Spacer



Start Date: 6/23/2011

Required Date: 6/29/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Rev C dwg 07-12-06 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.500W.049		Purchased	No			100	f	327.3512	0.283	5.957895			
6061-T6 RD Tube .500 x.049W													

Location

MAT014

117270

Loc Qty

327.351211

327.351211

Loc Code

257



SD

11/7/16

8/24

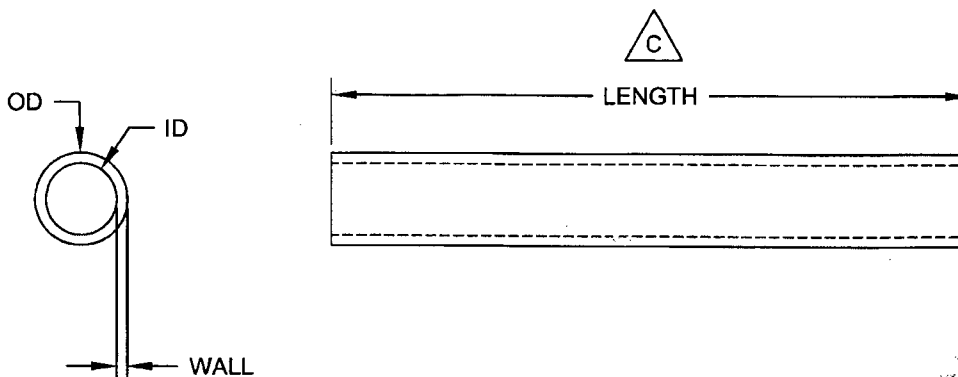
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71130

D3504-1/-3/-5 CROSS BOLT SPACER PARTS LIST

CL11/06/23

PART NUMBER	OD	WALL	LENGTH +0.030 -0.000	ID	MATERIAL SPEC	NOTE
D3504-1	0.500	0.049	3.475	0.402 (REF)	M6061T6T0.500W.049	SEE NOTE 1a)
D3504-3	0.375	0.049	3.475	0.277 (REF)	M6061T6T0.375W.049	SEE NOTE 1a)
D3504-5	0.750	0.080 (REF)	3.400	0.590	M6061T6R0.750	SEE NOTE 1b)



D3504-1/-3/-5 CROSS BOLT SPACER:

- 1) MATERIAL: a) 6061-T6 OR 6061-T62 TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6TD.DDDW.TTT)
- b) 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R0.750)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED
07.11.16

REV.	ADD -5	DC	07.09.19
B	3.475 WAS 3.400	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>DC</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	D3504	SHEET 1 OF 1
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	CROSS BOLT SPACER	NTS
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